

DART AEROSPACE LTD	Work Order:	22128
Description: Bushing	Part Number:	D2617-5
Dwg: D2617 Rev. D1	Qty:	25
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	U	04/2-21	24
2	MC	Machine as per Folio FA438 and Dwg D2617 Material: 6061-T6 (QQ-A-225/8 or QQ-A-200/8 or WW-T-700/6) Ø0.500" tubing x 0.058" wall (M6061T6T0.500W.058) Identify as D2617-5 Batch: M15197	me	05/01/03	25
3	QC2	Inspect parts as they come off the CNC machine	me	05/01/03	25
4	QC8	Second check	B	05/01/03	25
5	GA	Deburr break all unmarked sharp edges 0.005 to 0.010	BE	05-01-03	25
6	FP	Acid Etch and Alodine as per QSI 005 4.1	BE	05-01-03	25
7	QC5	Inspect work to Step 6	S	05-01-03	25
8	ST	Identify and Stock	JL	05-01-03	25
9	AC	Cost / part: .55	S	05-01-04	25
10	DC	Close W/O 1,08 Inspect Level 21	KA	05.01.06	25

Rev	Date	Change	Revised By	Approved
D	98.04.16	Re-Format	KB	
E	99.08.23	Re-format, added notes and inspection level	EC	
F	01.01.03	Re-format, made in-house	EC	
G	01.01.08	Updated material NCR 467	EC	
H	04.07.14	Reformat; added step 5	KJ/JLM	

RELEASED

05/07/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

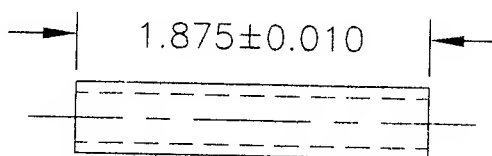
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

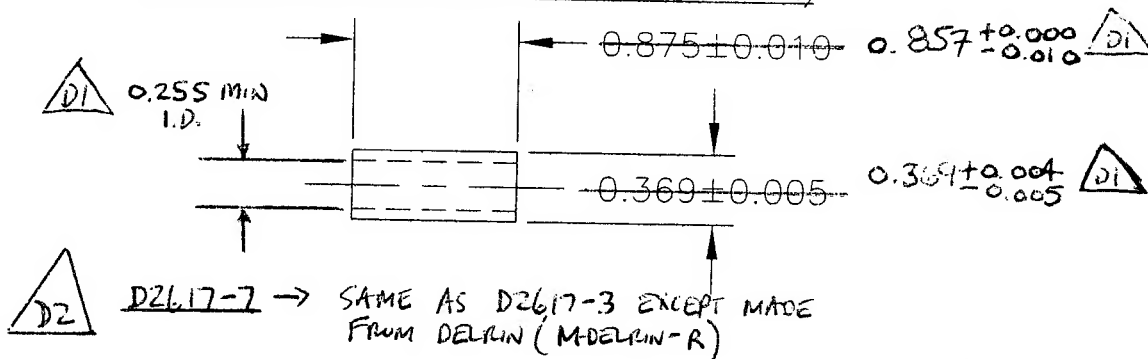


DESIGN BW		DRAWN BY CP		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #		APPROVED #		DRAWING NO. D2617	
DATE 01.07.04				REV. D SHEET 1 OF 1	
		TITLE BUSHING		SCALE 1:1	
A	96.10.08		NEW ISSUE		
B	97.05.08		.875 WAS 1.125		
C	97.06.04		0.369 DIA WAS 0.375		
D	01.07.04		ADD MAT'L SPEC AND TOL./DIM. NOTE		
D1	CP-#	04.07.12	CORRECT TOLERANCE (NCR 779)		

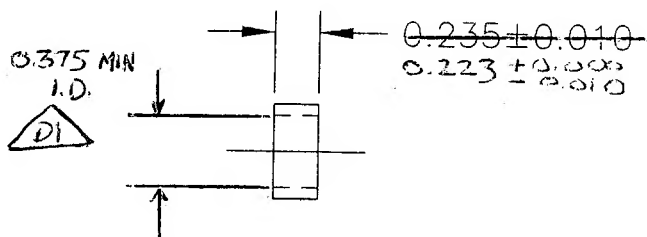
D2617-1 (0.375 OD x 0.058 WALL)



D2617-3 (0.375 OD x 0.058 WALL)



D2617-5 (0.500 OD x 0.058 WALL)



RELEASED
01.07.05

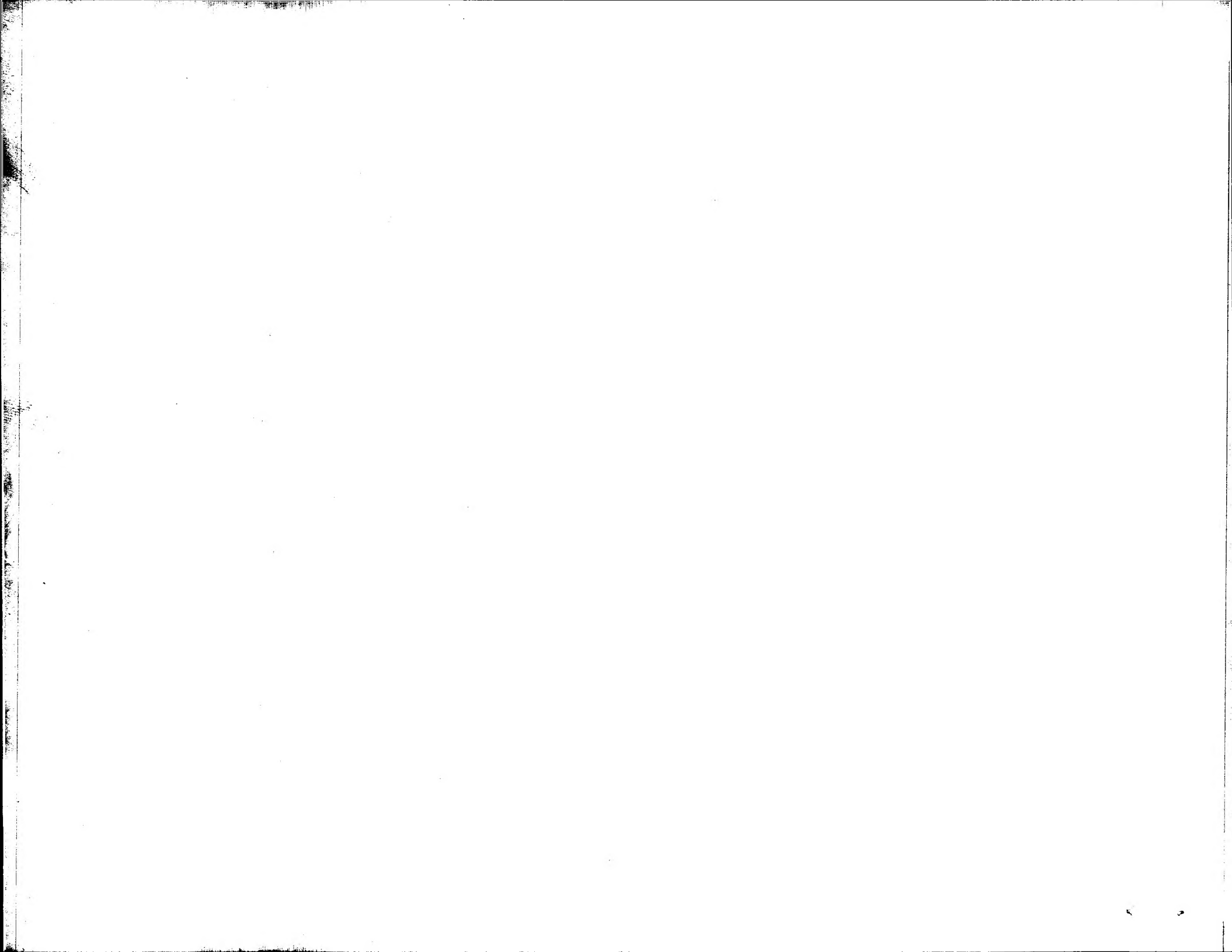
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11.22.28

NOTES:

- 1) MATERIAL: 5052-H32 (QQ-A-225/7 OR WW-T-700/4)
OR 6061-T6 (QQ-A-225/8, QQ-A-200/8, OR WW-T-700/6)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH, ALODINE PER QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Dec 21, 2004
02:09 pm

Work Order No : 0022128
Project Name : D2617-5
Project For : WK502
Work Order Type : Main
Main WO Number :
House Part Number : D2617-5
Description : Spacer
Manufactured : Yes
Amount Req'd : 24
Amount Done : 0
Start Date : 12-21-04
Est Finish Date : 01-03-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Mark up	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00